

Work Order ID 140352

Tuesday, December 22, 2015 3:09:47 PM

140352

gan, gtr

Page 1

Item ID: D350-591-311

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 12/22/2015 Start Qty: 10.00

10

Cust Item ID:

Required Date: 1/8/2016 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: MF Date: 15-12-22 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D3272	Rev B
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100	Document Control DOCUMENT CONTROL	0.00							
-----	--------------------------------------	------	--	--	--	--	--	--	--

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

10

DAS
28
9-89

JAN 18 2016

MCS 16-01-14
12

110

0.00

110

Large Fab

Large Fab

Memo

0.05

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/RAluminum Rod M32917/M31562

3-Grind End Plate flush

10

0

BE 16-01-04

Work Order ID 140352

Tuesday, December 22, 2015 3:09:47 PM

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Item ID: D350-591-311

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 12/22/2015 Start Qty: 10.00

10

Cust Item ID:

Required Date: 1/8/2016 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
120									
QC	Memo	0.00							
Quality Control									
130	QC5- Inspect part completeness to step on W/O	0.00							
130									
QC	Memo	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.03							
Hand Finishing									

x10 hrs of all 16/01/08

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Item ID: D350-591-311

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N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 12/22/2015 Start Qty: 10.00

10

Cust Item ID: /

Required Date: 1/8/2016 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

QC7-Inspect Chemical Conversion Coat

0.00

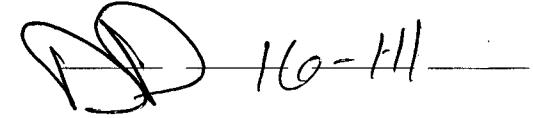
150

QC

Memo

0.00

Quality Control



180

Large Fab

0.00

180

Large Fab

Memo

0.05

Large Fab

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

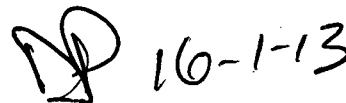
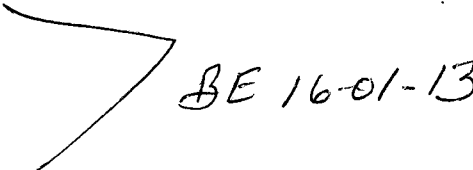
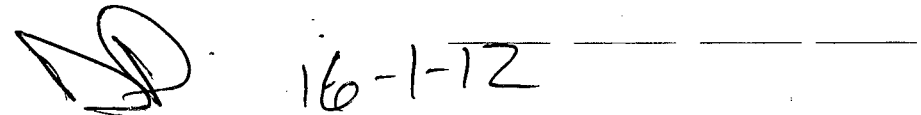
3-Bevel Aft end for welding

4-Inspect for foreign object as per OSI 024

5-Weld Aft End Plate as per OSI 004 & Dwg D3272
A/RAluminum Rod MB1562

6-Grind End Plate flush

7-Install last rivet as per Dwg.



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Item ID: D350-591-311
 Revision ID:
 Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible
 Start Date: 12/22/2015 Start Qty: 10.00
 Required Date: 1/8/2016 Req'd Qty: 10.00
 Reference:

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
220	<i>m 13374.</i>					<i>10</i>	<i>0</i>	<i>16-01-14</i>	<i>333</i>
Powdercoat	Memo	0.03							
Powder Coating	START TIME <i>10:30</i> OVEN TEMPERATURE <i>320°</i> FINISH TIME <i>11:00</i>								
230	Wing Walk as per dwg QSI005 4.4 Batch <i>111334006</i>								
230									
HandFinish	Memo	0.03							
Hand Finishing									
240	QC3- Inspect Part Finish	0.00							
240									
QC	Memo	0.00							
Quality Control									

DAS
38
9-89

JAN 15 2016

Work Order ID 140352***140352***

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Item ID: D350-591-311

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 12/22/2015 Start Qty: 10.00

10

Cust Item ID:

Required Date: 1/8/2016 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00							
250									
Packaging	Memo	0.00				10	DAS 6 9-89	27 9-89	JAN 1 15 2016
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
260									
QC	Memo	0.01				10	DAS 28 9-89		JAN 1 8 2016
Quality Control									
270	Packaging	0.00							
270									
Packaging	Memo	0.00				10	DAS 28 9-89		JAN 1 8 2016
Packaging	Identify and pack for shipping as per RPPD350-591-311 Location : FG084								

Sold

Work Order ID 140352***140352***

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Item ID: D350-591-311

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Stop ***NS2***

Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 12/22/2015 Start Qty: 10.00

10

Cust Item ID:

Required Date: 1/8/2016 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC21- Final Inspection - Work Order Release	0.00							
280									
QC	Memo	0.02							
Quality Control									

MC

JAN 18 2016

MC

JAN 18 2016

Picklist Print

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Work Order ID: 140352

140352

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 12/22/2015

Required Date: 1/8/2016

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP Rev:A04.03.22New issue KJ/RF

IPP Rev:B 07-06-09 Added D3272-1 JLM

IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified

by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3272-1

Manufactured

No

110

Each

0.0000

1

10

D3272-1

Step

D3067-1

Manufactured

No

110

Each

15.0000

1

10

D3067-1

End Plate

Location

Loc Qty

Loc Code

WA003

15

136692

1

156944

14

D3219-1

Manufactured

No

110

Each

37.0000

2

20

D3219-1

Plate

Location

Loc Qty

Loc Code

WA003

37

138871

37

D3066-1

Manufactured

No

180

Each

8.0000

2

20

D3066-1

Spacer

Location

Loc Qty

Loc Code

WA003

8

138018

8

139086

20

3140358 * 10

BE 16-01-05

BE 16-01-05

BE 16-01-05

20 +1

16-1-12

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification ☐	☐	Pressure/Forced ☐	☐	Temperature/Cure ☐	☐
Design ☐	☐	Operator ☐	☐	Bending ☐	☐	Set-up ☐	☐
Doc/Data ☐	☐	Offset/Setup ☐	☐	Centre Not Concentric ☐	☐	BOM/Route ☐	☐
Equip/Tooling ☐	☐	Supplier ☐	☐	Cracks ☐	☐	Broken/Damage/Defect ☐	☐
Handling/Pre ☐	☐	Training ☐	☐	Crimp/Kink/Ripple/Wave ☐	☐	Inspection Incomplete/Unqualified ☐	☐
Material ☐	☐	Use for Testing ☐	☐	Cuffs ☐	☐	Contamination ☐	☐
Internal Transport ☐	☐	Poor Information ☐	☐	Crushing ☐	☐	Countersink ☐	☐
Tribal Knowledge ☐	☐	Rushing ☐	☐	Heat Treat ☐	☐	Cut Too Short ☐	☐
LOA ☐	☐	Product Improvement ☐	☐	Wave/Twist in Tube ☐	☐	Instructions Incomplete/Unclear ☐	☐
Substation ☐	☐	Process Improvement ☐	☐	Marks/Chatter ☐	☐	Drill Holes ☐	☐
Past Expiry Date ☐	☐	Manufacturing Process ☐	☐	OTHER : _____ _____ _____			
Misidentified ☐	☐	Past Due ☐	☐				

Picklist Print

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Work Order ID: 140352

140352

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 12/22/2015

Required Date: 1/8/2016

Start Qty: 10.00

Required Qty: 10.00

MS20600-AD4W4

Purchased

No

180

Each

218.0000

16

160

MS20600-AD4W4

Rivets

**

Location

Loc Qty

Loc Code

ST308

204

M132640

204

WA003

14

M132256

14

D3065-041

Manufactured

No

180

Each

34.0000

1

10

D3065-041

Step Leg Assembly

**

Location

Loc Qty

Loc Code

WA002

34

138014

10

138914

24

D3067-1

Manufactured

No

180

Each

15.0000

1

10

D3067-1

End Plate

**

Location

Loc Qty

Loc Code

WA003

15

136692

1

136944

14

AN3-35A

Purchased

No

250

Each

60.0000

2

20

AN3-35A

Bolt

**

Location

Loc Qty

Loc Code

FG

10

122800

10

ST348

50

m133363

2

m133577

48

DAS
28
9-89

DAS

8

9-89

JAN 14 2016

Tuesday, December 22, 2015 3:09:46 PM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																									
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : ☐			
Misidentified ☐	Past Due ☐																																																																

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Work Order ID: 140352

140352

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 12/22/2015

Required Date: 1/8/2016

Start Qty: 10.00

Required Qty: 10.00

D3235-1

Manufactured No

250

Each

97.0000

2

20

D3235-1

Mounting Lug

DAS
28
9-89
STO 27
9-89

Location

Loc Qty

Loc Code

ST521

95

108670

13

137133

32

138591

50

ST539A

2

116383

2

D3278-041

Manufactured No

250

Each

36.0000

1

10

D3278-041

Support Assembly

DAS
28
9-89
JAN 14 2016

Location

Loc Qty

Loc Code

ST522

36

138012

16

138878

20

DAS
28
9-89

10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
☐ OTHER : _____					

Picklist Print

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Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 12/22/2015

Required Date: 1/8/2016

Start Qty: 10.00

Required Qty: 10.00

NAS1149D0463J

Purchased

No

250

Each

2,708.000

16

160

NAS1149D0463.J

WASHER

DAS
27
9-89

JAN 14 2016

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

432

M129390

41

M132035

391

ST263

852

M133284

32

M133316

820

ST269

1424

M129682

39

M130799

361

M132317

101

M132677

888

M133077

35

160

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Start Date: 12/22/2015

Required Date: 1/8/2016

Start Qty: 10.00

Required Qty: 10.00

NAS1149D0563J

Purchased

No

250

Each

1,211.000

4

40

10

NAS1149D0563J

Washer

**DAS
27
9-89**

**DAS
6
9-89**

**DAS
28
9-89**

Location

Loc Qty

Loc Code

GA	53	
m125807	53	
ST260a	520	
m130799	55	
m132035	55	
m132256	10	
m133769	400	
ST263	463	
m133134	129	
m133363	334	40
ST269	156	
m128257	156	
ST271	19	
m131026	19	

AN5-36A

Purchased

No

250

Each

39.0000

2

20

10

AN5-36A

Bolt

133990

**DAS
27
9-89**

**DAS
6
9-89**

JAN 14 2016

**DAS
28
9-89**

Location

Loc Qty

Loc Code

ST299A	1	
M131957	1	
ST336	15	
M130466	15	
ST399a	23	
M133577	23	

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Parent Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 12/22/2015

Required Date: 1/8/2016

Start Qty: 10.00

Required Qty: 10.00

D2618 Manufactured No 250 Each 77.0000 2 20

DAS 68-6 27 9-89 SVQ

D2618

Bushing

DAS 28 9-89

Location Loc Qty Loc Code

ST008A 15

137715 15

ST012a 62

138990 20

139586 42

D2230-3 Manufactured No 250 Each 152.0000 4 40

DAS 68-6 27 9-89 SVQ

D2230-3

Mounting Lug

DAS 28 9-89

Location Loc Qty Loc Code

FG 8

109344 4

89045 4

ST521 64

132403 24

138587 40

ST525A 80

137522 80

D2856-400 Manufactured No 250 f 174.6000 1.2 12

DAS 68-6 27 9-89 SVQ

D2856-400

Abrasion Strip 4" Wide (Per Foot)

DAS 28 9-89

Location Loc Qty Loc Code

ST418 174.6

134509 174.6

*** cut (2) at 7.20" (D2856-400-720) ***

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Parent Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 12/22/2015

Required Date: 1/8/2016

Start Qty: 10.00

Required Qty: 10.00

MS21042L3

Purchased

No

250

Each

1,697.000

2

20

10 ***MS21042L3***
Nut

DAS 27
6 9-89 9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FP001

185

m133790

185

GA

232

m133790

232

ST304

1280

m133790

1280

20

AN4-13A

Purchased

No

250

Each

174.0000

8

80

10 ***AN4-13A***
Bolt

DAS 27
6 9-89 9-89

133790 x 50

Location

Loc Qty

Loc Code

FG

20

122808

20

ST344

154

m133769

154

30

DAS
28
9-89

JAN 14 2016

Picklist Print

Tuesday, December 22, 2015 3:09:47 PM

Work Order ID: 140352

140352

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 12/22/2015

Required Date: 1/8/2016

Start Qty: 10.00

Required Qty: 10.00

MS21042L5

Purchased

No

250

Each

570.0000

2

20

DAS
27
9-89

10 *MS21042L5*

Nut

DAS
28
9-89

Location

Loc Qty

Loc Code

GA	146	
m127813	146	
ST303	300	
m133577	200	
m133790	100	
ST304	76	
m133363	76	
ST305	48	
m127813	19	
m131340	21	
m132123	8	

20

JAN 14 2016

Picklist Print

Tuesday, December 22, 2015 3:09:47 PM

Work Order ID: 140352

140352

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 12/22/2015

Required Date: 1/8/2016

Start Qty: 10.00

Required Qty: 10.00

MS21042L4

Purchased

No

250

Each

3,083.000

8

80

MS21042L4

Locknut

******DAS
27
9-89LocationLoc QtyLoc Code

FP001

137

m133363

137

GA

41

m127813

41

ST260a

92

m130799

56

m132262

36

ST303

2680

m133769

2680

ST305

133

m128300

8

m130388

4

m130922

97

m132123

24

DAS
28
9-89

NAS1149D0363J

Purchased

No

250

Each

885.0000

4

40

NAS1149D0363J

Washer

******DAS
6
9-89DAS
27
9-89LocationLoc QtyLoc Code

GA

129

m130799

129

ST263

756

m133709

256

m133790

500

DAS
28
9-89

JAN 14 2016



DESIGN <i>90</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07.06.04 *[Signature]*

△
B

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

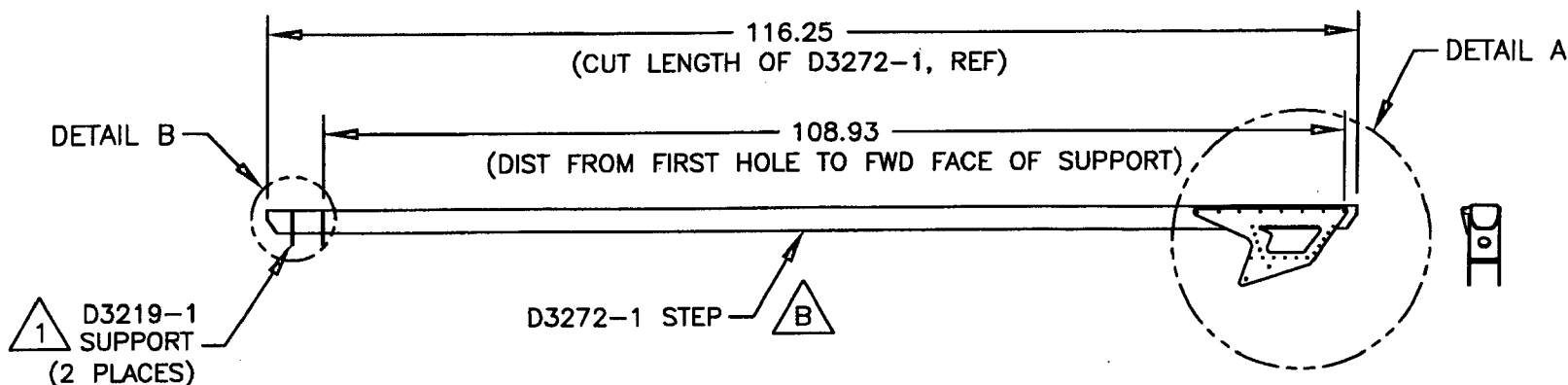
140555 *[Signature]*

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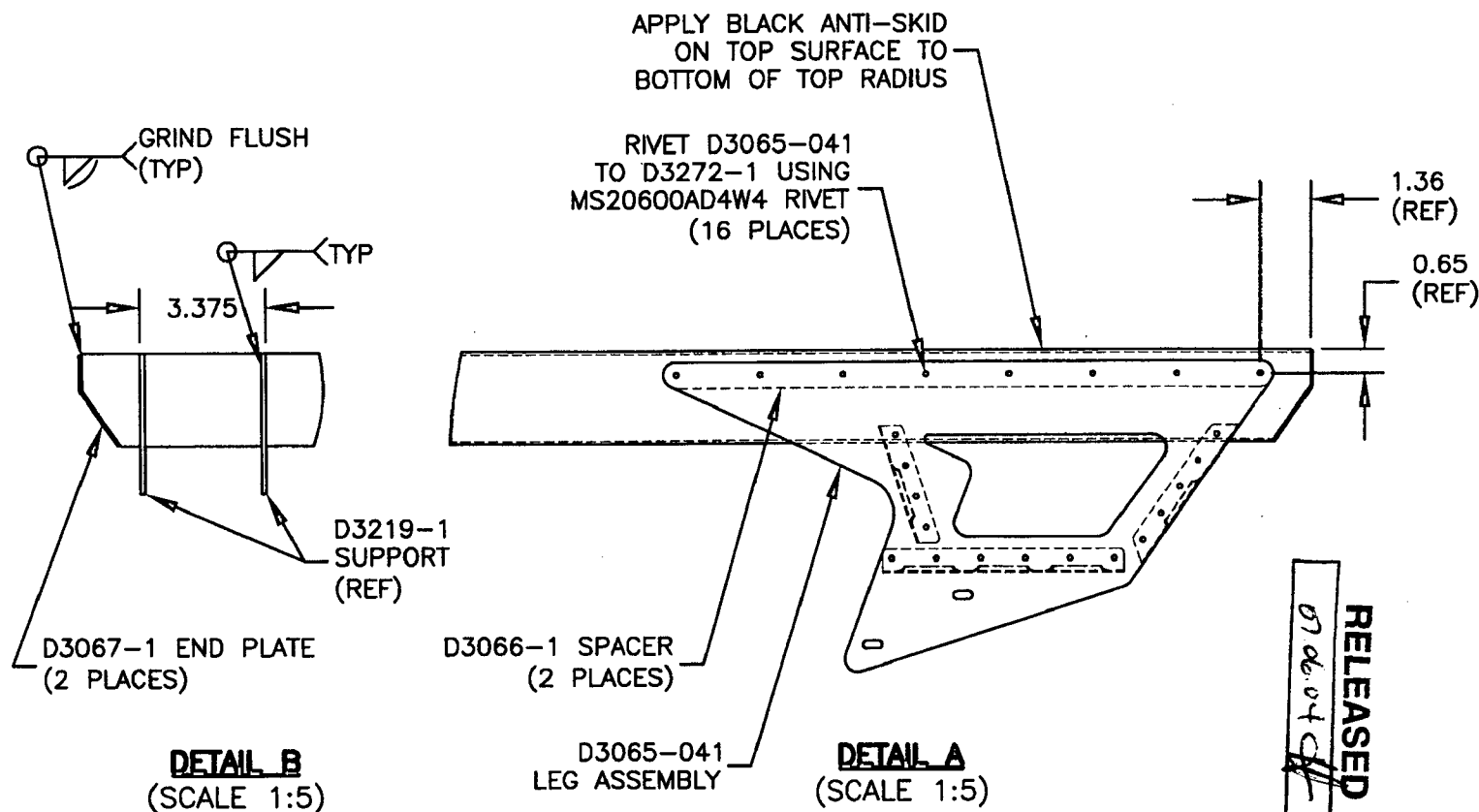
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DESIGN	q	DRAWN BY		DART AEROSPACE LTD
CHECKED	CE	APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	07.05.18	DRAWING NO.	D3272	REV. B
		TITLE	STEP ASSEMBLY, HI LONG	SHEET 2 OF 3
		SCALE	1:20	



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)

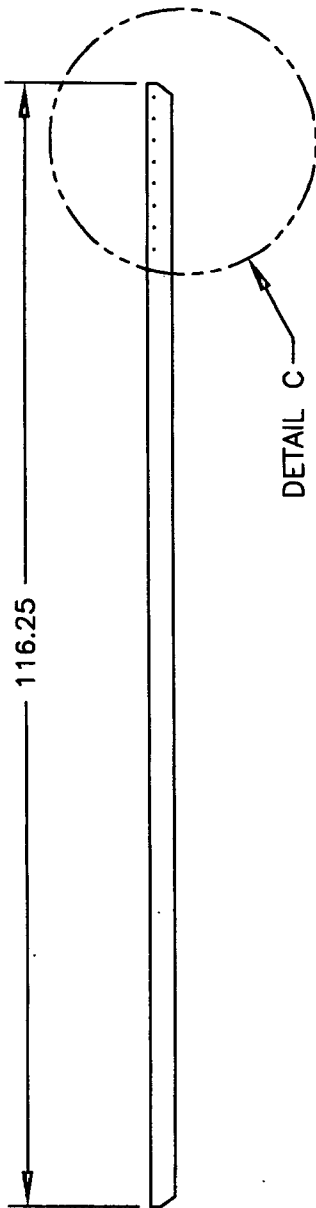




DESIGN 90	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

RELEASED

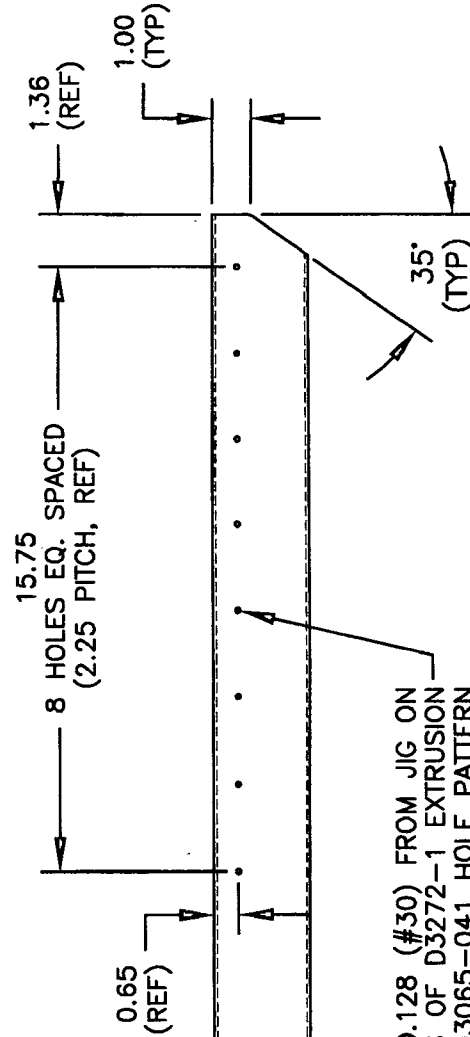
07.06.04 [Signature]



DETAIL C

B D3272-1 STEP

(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL $\phi 0.128$ (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

DETAIL C

(SCALE 1:5)

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DART AEROSPACE LTD.

DAS
28
9-89

D350-591
Page 23 of 23

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
	X							D350-591-212	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
		X						D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
			X					D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
				X				D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
					X			D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
						X		D350-591-311	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
							X	D350-591-312	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.